	r ID 59348 02, 2010 9:19:14 AM	1										Page 1
Item ID:	D212-580-041			Accept					Setup	Start		
Item Name:	Cargo Mirror Assembly			•						Stop		
Required Date: 6	-	ty: 1.00 Qty: 1.00			Cust Item I Customer:	D:						
Reference: Approvals:	Process Plan://	WC	Date: [0-6-	Tooling:	Da				Run	Start		
•	QC:		-			ite:				Stop		
Sequence ID/ Work Center ID	Operati Descrip			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr						,,,,,					
D2161	Rev B2											
DC Document Control	DOCUME	ENT CONTRO Memo Photocopy b	L luefile and create labels as	0.00 0.00 per PPP D212-580-041	CHG003	,		#	() (~ C	ic la	lodoy
110 Large Fab Large Fab	Large Fab	Memo 1-Assemble	on Jig DT8065 as per Dwş ıfy as D2161-212□A/R = S	0.00 0.00 g D2161□2-Weld as per SS ROD Batch: ► L L C		iloy		-EZ		10)-6-	> (×1
120 	QC5- Insp	ect part comple	eteness to step on W/O	0.00	wooloa			@	···			

Quality Control

W/O:			WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CH	IANGE		Ву	Date	Qty	Approval , Chief Eng / Prod Mgr	Approval QC Inspector			
Part No						NCR: Yes No DQA: Date:							
	Re	esolution:							Date: _				
NCR:			WORK OR	DER NON-CONFO	DRMANCE	(NCR)						
DATE	STEP	Description of NC	Initial	Corrective Action	Section B	Cian 0	Verific		Approval	Approval			
		Section A	Chief Eng	Action Descri	puon	Sign & Date	Section	on C	Chief Eng	QC Inspector			
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Work Order ID 59348

Wednesday, June 02, 2010 9:19:14 AM



Page 2

Item ID:

D212-580-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Cargo Mirror Assembly

Start Date: 6/2/2010 Required Date: 6/3/2010

Start Qty: 1.00

Req'd Qty: 1.00

Cust Item ID: **Customer:**

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date: Date:

Tool # Plan

Code

Run Start

Stop



Sequence ID/ **Work Center ID**

130

OC Quality Control Operation Description

OC: ______

QC9- Inspect visual per QSI004- Fusion Welds

Set Up/ **Run Hours**

0.00

0.00

Accept

Qty

Reject Oty

Reject Number Stamp

Insp.

D 10,06,02

140

Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QS1005 4.3

Memo

0.00

ME: 3:(50 -DOVEN TEMPERATURE:

=) H 10/06/07 1 9/

QC3- Inspect Part Finish

0.00

150

Memo

Memo

0.00

MM 10 02 03

Quality Control

W/O:			W	ORK ORDER CHANG	ES							
DATE	STEP	PRO	OCEDURE CHA	<u> </u>		Ву	Date	Qty	Approval , Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No		PAR #:	Fault Cate	egory:	NCR: Yes No DQA: Date:							
	R	esolution:	Disposition	on:	_ QA:	N/C Clo	sed:		Date: _			
NCR:			WORK ORD	DER NON-CONFORMA	ANCE	(NCR			77 ¹ 10 4			
DATE	STEP	Description of NC		on B	<u> </u>	Verific	cation	Approval	Approval			
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector		
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Work Order ID 59348

Wednesday, June 02, 2010 9:19:14 AM

6/2/2010



Page 3

Item ID:

D212-580-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Cargo Mirror Assembly

Cust Item ID:

Customer:

Start Date:

Required Date: 6/3/2010

Start Qty: 1.00 Req'd Qty: 1.00

Date: _____

Reference:

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Date:

Tool ID

Run

Start

Stop

Sequence ID/

Work Center ID

160

Packaging

Packaging

Operation **Description**

Pick Kit

Memo

Set Up/ **Run Hours**

0.00

0.00 7 m.d. 10/06/03

Tool # Plan

Code

Qty

Date:

Accept

Reject Qty

Reject Number Stamp

Insp.

170

Quality Control

QC4-100% Inspect kits for completeness

180

Packaging

Packaging

Memo

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D212 380-041 □ Location: □PPP Rev:

W/O:			WORK ORDER CHANGES											
DATE	STEP	PR	OCEDURE CH	IANGE		Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No	:	PAR #:	Fault Ca	tegory:		NCR: Y	es N	o DQ	4:	Date:				
		solution:												
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DATE	STEP	Description of NC		Corrective				Verific	ation	Approval	Approval			
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Work Order ID 59348

Wednesday, June 02, 2010 9:19:15 AM



Page 4

Item ID:

D212-580-041

Accept



Setup Start

Revision ID:

Item Name: Cargo Mirror Assembly

Start Date:

6/2/2010

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:	
Axpprovais.	

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop

QC:

Required Date: 6/3/2010

Date: _____

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

Operation Description

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours** Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

190

Memo

0.00

0.00

Quality Control

		— · •-											
W/O:			WC	RK ORDER CHANG	ANGES								
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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NCR:			WORK ORDI	ER NON-CONFORM	ANCE (NC	R)							
DATE	STEP	Description of NC		tion B	Verifi	cation	Approval	Approval					
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Picklist Print Wednesday, June 02, 2010 9:19:14 A	М										Page 1
Work Order ID: 59348 Parent Item: D212-580-041											3
Parent Item Name: Cargo Mirror Asse Comments: IPP Rev:H Remo		06-03-2	22 JLM					tart Date: 6/2/ Start Qty: 1.00			d Date: 6/3/2010 ed Qty: 1.00
Component Item ID/ Replacement Item Name Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit		Qty Issued	Date Status Issued
CCR264SS3-2 Rivet, Cherry	Purchased	No			170	Each	228.0000	4	J ₄		
-D2011-103	Manufactured	No	<u>Locatio</u> ST311	106578 108738 112314	<u>Loc (</u>	Oty 228 45 83 100 Each	Loc Code 57.0000		4 ★ 2	- - - M -	10/06/03
D2013-3	Manufactured	No	<u>Locatio</u> ST226	52198 58399	<u>Loc (</u>	Otv 57 7 50 Each	Loc Code 5.0000	. —	ax 1	m	1 10/06/06/06/06/06/06/06/06/06/06/06/06/06
D2013-4	Manufactured	No	<u>Locatio</u> WA	n 58370	<u>Loc (</u>	Oty 5 5 Each	Loc Code 5.0000				-6-2

Loc Oty

5 5 Loc Code

Location

58371

WA

W/O:			ORK ORDER CHANGI	ES			•	
DATE	STEP	PRO	OCEDURE CH	IANGE	Ву	Date Qt	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				•				
						•		
Part No		PAR #:	Fault Ca	tegory:	NCR: Yes	No DQA:	Date: _	
	Re	esolution:	Disposit	ion:	_ QA: N/C CI	osed:	Date: _	
NCR:			WORK OR	DER NON-CONFORMA	NCE (NCR	3)		:
DATE	STEP	Description of NC		Corrective Action Section		Verification	n Approval	Approval
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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Wednesday, June 02, 2010 9:19:14 AM

Work Order ID: 59348

D212-580-041

Parent Item Name:

Cargo Mirror Assembly

Comments:

Parent Item:

IPP Rev:H Removed D2013-3/-4 06-03-22 JLM

No

Start Date: 6/2/2010

Required Date: 6/3/2010

Start Qty: 1.00

Required Qty: 1.00

											-	- •	
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2037-101		Manufactured	No			170	Each	9.0000	1	1 A	10	- 6 -3	-
				Location	!	Loc	<u>Qty</u>	Loc Code					
				WA			9				_		
					52272		9				_	,	
MS21059L3,		Purchased	No			170	Each	154.0000	2	2 -	, 		

Location	<u>1</u>	<u>Lo</u>	c Qty	Loc Code	
ST301			100		
	114718		100		
ST302	,		54		
	113749		10		
	113749 114456		44		
		100	Each	1,501.000	4

2 x m- / 10/06/03

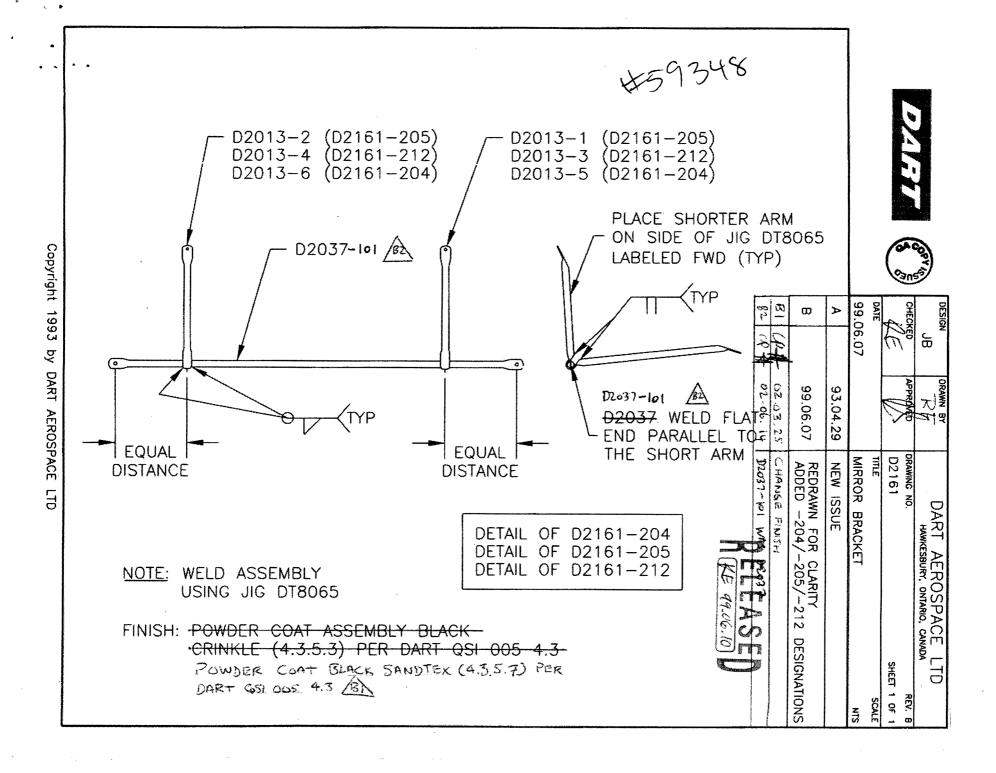


Screw

Location	Loc Qty	Loc Code
ST291	1501	
110552 110835	44	
110835	1257	
114718	200	

=== m-h 10/06/03

W/O:			WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	, [Date	Qty	Approval . Chief Eng / Prod Mgr	Approval QC Inspector				
	;													
Part No	:	PAR #:	Fault Cate	enory:	NCP: V	os Na	> DOA	\ <u>.</u>	Data					
	Resolution:					QA: N/C Closed: Date:								
NCR:				ER NON-CONFORM										
DATE	STEP	Description of NC		Corrective Action Section B				ation	Approvai	Approval				
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		gn & ate	Section		Chief Eng	QC Inspector				



W/O:		WORK ORDER CHANGES .												
DATE STEP		PRO		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector						
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		PAR #:	PAR #: Fault Category:				NCR: Yes No DQA: Date:							
			Disposition:											
NCR:		V	VORK ORDI	ER NON-CONFORI	MANCE	(NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section			0:	Verifica	Verification	Approval	Approval				
			Initial Chief Eng	Action Descriptio Chief Eng	n	Sign & Date	Section	Section C	Chief Eng	QC Inspector				
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D212-580 Page 8 of 8

WEIGHT AND BALANCE 4.0



		LA	TERAL	LONGITUDINAL		
Installation	Weight	Arm	Moment	Arm	Moment	
D204-562-041	5.0 lb	0 in	0 lb-in	3.80 in	19.0 in-lb	
Dual Mirror Installation	2.3 kg	0 m	0 kg-m	0.10 m	0.23 m-kg	
D205-563-041	5.0 lb	0 in	0 lb-in	3.80 in	19.0 in-lb	
Dual Mirror Installation	2.3 kg	0 m	0 kg-m	0.10 m	0.23 m-kg	
D212-580-041	5.0 lb	0 in	0 lb-in	-5.25 in	-26.3 in-lb	
Dual Mirror Installation	. 2.3 kg	0 m	0 kg-m	-0.13 m	-0.30 m-kg	

5.0 PARTS LIST

Qty	Qty	Qty/	Part Number	Description
562	563	580	,	
-041	, -041	-041	1 g	
Х			D204-562-041	DUAL MIRROR INSTALLATION
. Adupt the	Х		D205-563-041	DUAL MIRROR INSTALLATION
		Х	D212-580-041	DUAL MIRROR INSTALLATION
2	2	<i>f</i> 2	D2011-103	MIRROR
. 1			D2161-204	MIRROR BRACKET
	1		D2161-205	MIRROR BRACKET
		1	D2161-212	MIRROR BRACKET
*2	*2	*2	D3015-3	LOCKNUT
*2	· *2	*2	AN960JD516	WASHER
		/4	CCR264SS-3-2	RIVET, BLIND
·	•	/2	MS21059L3	NUTPLATE
4	4	/ 4	MS27039-1-08	SCREW

^{*} PARTS ARE INCLUDED WITH D2011-103 MIRROR

C Revision: Date: 08.01.28

W/O:			V	ORK ORDER CHANGE	ES						
DATE	STEP	PROCEDURE CHANGE				у	Date Qty Approval Chief Eng / Prod Mgr QC Insp				
		·									
Part No:PAR		PAR #:	Fault Ca	NCR: \	CR: Yes No DQA: Date:						
						A: N/C Closed: Date:					
NCR:		V	ORK OR	DER NON-CONFORMA	NCE (I	ICR)					
DATE	OTED	Description of NC	Corrective Action Section B			- 	Verific	ation	Approval	Approval	
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